

Work Order ID 135152

Thursday, July 30, 2015 3:06:51 PM

135152

Page 1

Item ID: D2011-101 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mirror 6" **\$19** JUL 31 2015
 Start Date: 7/30/2015 Start Qty: ~~12.00~~ ***12*** Cust Item ID:
 Required Date: 7/30/2015 Req'd Qty: ~~12.00~~ ***12*** Customer:
 Reference:

Approvals: Process Plan: MNF Date: 15-7-20 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2011	Rev G

100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>29342</u> Mirror P/N: <u>CHM10001</u> Possible supplier:								
	Auto Parts Extra Material release note required <u>28663</u>								
	<u>BC Industrial</u>								

C2 JUL 31 2015 19

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								

19x SP15-08-04

120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

19 DMS 38 Aug 6 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Page 2

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mirror 6"

Start Date: 7/30/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 7/30/2015 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130									
Small Fab	Memo	0.01							
Small Fab	1- Wrap mirror with plastic wrap								
	2- Discard Hardware & Install new hardware loosely								
	3- Crimp stud as per Dwg D2011								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control	4- Test assembly to 50lbs pull test after 24 hours								
150	Identify as per dwg & Stock Location: <u>ST384</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									

19x 15/08/07 DAS 36 9-89

(19) DAS 38 9-89 AUG 10 2015

DAS 26 9-89 (19) JA AUG 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.02							
Quality Control									

ML5 AUG 11 2015

ML5 AUG 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

Picklist Print

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Page 1

Work Order ID: 135152

135152

Parent Item: D2011-101

D2011-101

Parent Item Name: Mirror 6"

Start Date: 7/30/2015

Required Date: 7/30/2015

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: J04.09.15 Added Steps 5-7 KJ/JLM IPP:
K05.12.15 chg black sikaflex for white EC IPP L 08.11.06 new
drawing EC verify: DD IPP: M 08.12.19 Added step 3 KJ Verified
by: LL IPP rev N 10.01.13 added wrap per ncr09-118 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CHM-10601 28663 CHM-10601* Mirror 6"		Purchased	No			130	Each	0.0000	1	19		19x8p15-08-04	
D2829		Manufactured	No			130	Each	89.0000	1	12		15/08/07	DAS 36 9-89
D2829 Threaded Stud													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		89							
				122346		89							
D3014-1		Manufactured	No			130	Each	215.0000	1	12		15/08/07	DAS 36 9-89
D3014-1 Lock Nut													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST015		215							
				113644		15							
				122272		200							
NAS1149D0416J		Purchased	No			110	Each	4,745.000	1	12		15/08/07	DAS 36 9-89
NAS1149D0416J WASHER													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		401							
				m131511		401							
				ST270		4344							
				m131511		4344							

DQA: _____ Date: _____

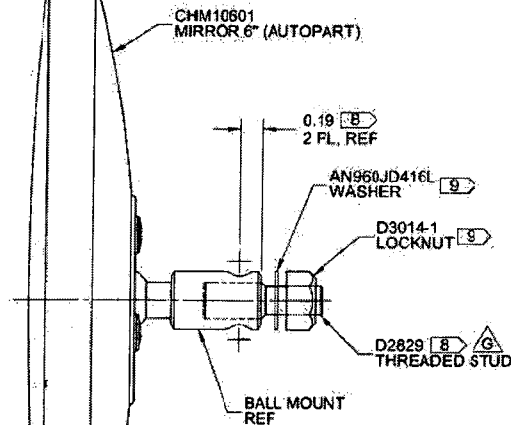


WORK ORDER NON-CONFORMANCE / UPDATE

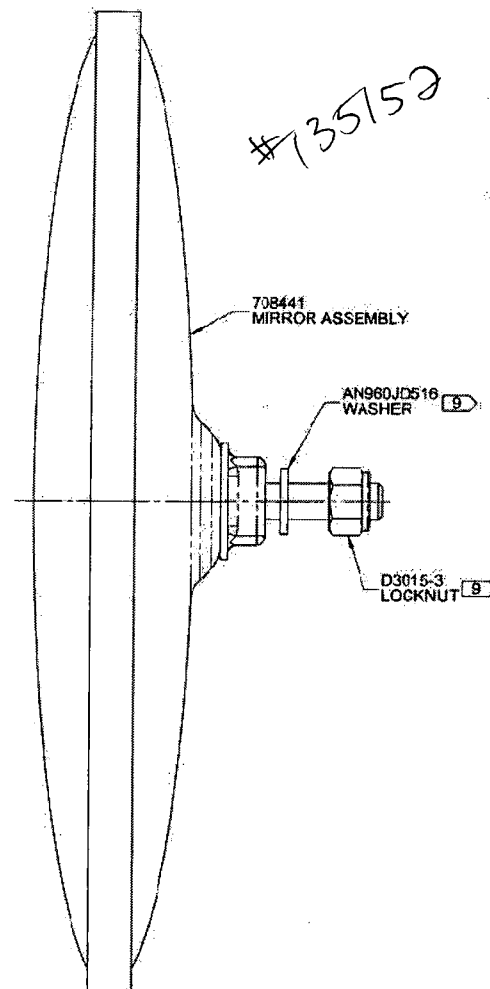
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



D2011-101 MIRROR ASSEMBLY 6"



D2011-103 MIRROR ASSEMBLY 8"

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2011-101 = 0.6 lbs APPROX. ; D2011-103 = 1.0 lbs APPROX.
- 8) D2829 INSTALLATION PROCEDURE:
 - APPLY LOCKTITE 262 TO Ø5/16 END OF D2829
 - THREAD BY HAND INTO BALL MOUNT UNTIL ENTIRE Ø5/16 END OF D2829 IS WITHIN BALL MOUNT
 - CRIMP BALL MOUNT ON TWO OPPOSING SIDES, 0.19 FROM END AS ILLUSTRATED USING TOOL DT8317
 - CRIMP TO DEPTH OF 0.040±0.010 USING R0.125.
- 9) INSTALL LOOSE

ITEM	QTY -101	QTY -103	P/N	DESCRIPTION
1	X		D2011-101	MIRROR ASSEMBLY 6"
2		X	D2011-103	MIRROR ASSEMBLY 8"
3	1		D2829	THREADED STUD
4	1		D3014-1	LOCKNUT
5		1	D3015-3	LOCKNUT
6	1		CHM10601	MIRROR 6" (AUTOPART)
7		1	708441	MIRROR 8" (VELVAC)
8	1		AN960JD416L	WASHER
9		1	AN960JD516	WASHER

RELEASED
C6-10-29-11

G	REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO "B" SIZE FORMAT. MIRROR 6" (AUTOPART) AND CHM10601 WERE MIRROR 6" (GROTE) AND P/N 58043 (ZIN D3-1); ADDED D2829 (ZIN D3-1 AND ZIN C6-1); REMOVED DRILLING NOTE, VIEW A-A AND SIKAFLEX APPLICATION NOTE. REASON: GROTE PRODUCT IS DISCONTINUED	MB	08.10.06
F	ADD HOLES FOR SEALANT, ON -101	CP	04.09.10
E	NEW 8" MIRROR	CP	01.05.08
D	NEW 6" MIRROR, ADD NUT, REMOVED STUD	CP	01.04.23
C	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN	RF	09.06.01
B	SIKAFLEX 241 ADDED	JB	08.04.09
A	DWG NO. WAS DSP1011, ADDED -103	JB	00.06.15
-	NEW ISSUE	JB	00.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	JB		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.06		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2011 TITLE MIRROR ASSEMBLY SHEET 1 OF 1 SCALE NTS COPYRIGHT © 1990 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION OF DART AEROSPACE LTD			

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29342**

Purchase Order Date 7/31/2015 8:08:29 AM

PO Print Date 7/31/2015

Page Number 1 of 1

Order From :

VC-BCI001

B C INDUSTRIAL
14 OLD FOREST
KIRKLAND, QUEBEC H9J 2Z8

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

REVISED

Contact Name

Vendor Phone 514-585-8907

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

COD

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	28663 AS PER DWG D2011 REV. G B135152	Mirror 6"	8/4/2015 Yes 8/4/2015	FN	19.00 Each	\$18.70	\$355.30
Line Total:							\$355.30
2	71401-45	PROCUREMENT QUALITY CLAUSES	8/4/2015 No 8/4/2015		1.00	\$0.00	\$0.00
Line Total:							\$0.00
PO Total:							\$355.30

cy
Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 2

Change Date: 7/31/2015

BC Industrial..... 14 Old Forest....Kirkland....Quebec....H9J-2Z8....Canada

Phone 514-585-8907

Email bcpc1@sympatico.ca

FACTURE/INVOICE

INV150731DA

July 31 2015

Ref Notre PS# PS1500731DA

Votre PO# 29342

Vendu a Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ont
K6A 1K7

Description	Quan.	Prix	Total
1. mirror 28663	19 ✓	18.70ea	355.30
2.			
3.			
4.			
5.			

8815-08-04

355.30

HST: 46.18

401.48

#TPS/GST-142640622

#TVQ/PST-1021696907

Terms 2%10 Net 30

DATE July 31 2015

Packing Slip

PS150731DA

Livrer a/Ship to:

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, Ont
K6A 1K7

PO 29342

	Description	Livrer/ship	B/O
1.	mirror 28663	19	0
2.			
3.			
4.			
5.			
6.			
7.			

BC Industrial..14 Old Forest..Kirkland..Quebec..H9J-2Z8

Phone 514-585-8907 bcpcl@sympatico.ca

BC Industrial'..... 14 Old Forest....Kirkland....Quebec....H9J-2Z8....Canada
Phone 514-585-8907 Email bcpc1@sympatico.ca

Certificate of Compliance

July 31 2015

Dart Aerospace
1270 Aberdeen
Hawkesbury, Quebec
K6A-1K7

ATT: Chantal Lavoie

This is to confirm that the parts delivered on our PS 150731DA

mirror 28663

conforms to the specifications outlined on your purchase
order 29342

Thank you



Bryan Cameron

#TPS/GST-142640622
#TVQ/PST-1021696907

Terms 2%10 Net 30